

Date: Tuesday, 10/02/2009 3:06:33 PM  
 User: Julie Dawson

## Process Sheet

|   |  |
|---|--|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services                               | <b>Drawing Name</b> : SPACEPOD DOOR LH                     |
| <b>Job Number</b> : 45691   |  |
| <b>Estimate Number</b> : 12635  |  |
| <b>P.O. Number</b> :  | <b>Part Number</b> : D31863                                |
| <b>This Issue</b> : 10/02/2009 <b>S.O. No.</b> :                                    | <b>Drawing Number</b> : D3186 REV.D                        |
| <b>Prsht Rev.</b> : NC  | <b>Project Number</b> : N/A                                |
| <b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS                              | <b>Drawing Revision</b> : D                                |
| <b>Previous Run</b> : 45690   | <b>Material</b> :  |
| <b>Written By</b> :   | <b>Due Date</b> : 05/03/2009 <b>Qty:</b> 1 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 09-02-10</u>                              |  |
| <b>Comment</b> : Est Rev:A New Issue 07-01-11 EC<br>est rev B rev D dwg 07.03.07 ec |  |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |        |                  |
|-----|--------|------------------|
| 1.0 | 45691A | SPACEPOD DOOR LH |
|-----|--------|------------------|



**Comment:** Sub-Component SPACEPOD DOOR LH  
 1 x D3186-1M Batch 45691A

|     |             |                               |
|-----|-------------|-------------------------------|
| 2.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)

*[Signature]*

090430

|     |     |                              |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



**Comment:** INSPECT WORK TO CURRENT STEP

*[Signature]* 090505

|     |             |                       |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location:

*[Signature]* P1045455 *[Signature]* 9/16 *[Signature]*

090506

|     |      |                              |
|-----|------|------------------------------|
| 5.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



**Comment:** FINAL INSPECTION/W/O RELEASE

09/05/07 *[Signature]*

Job Completion



MF 09-05-06

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

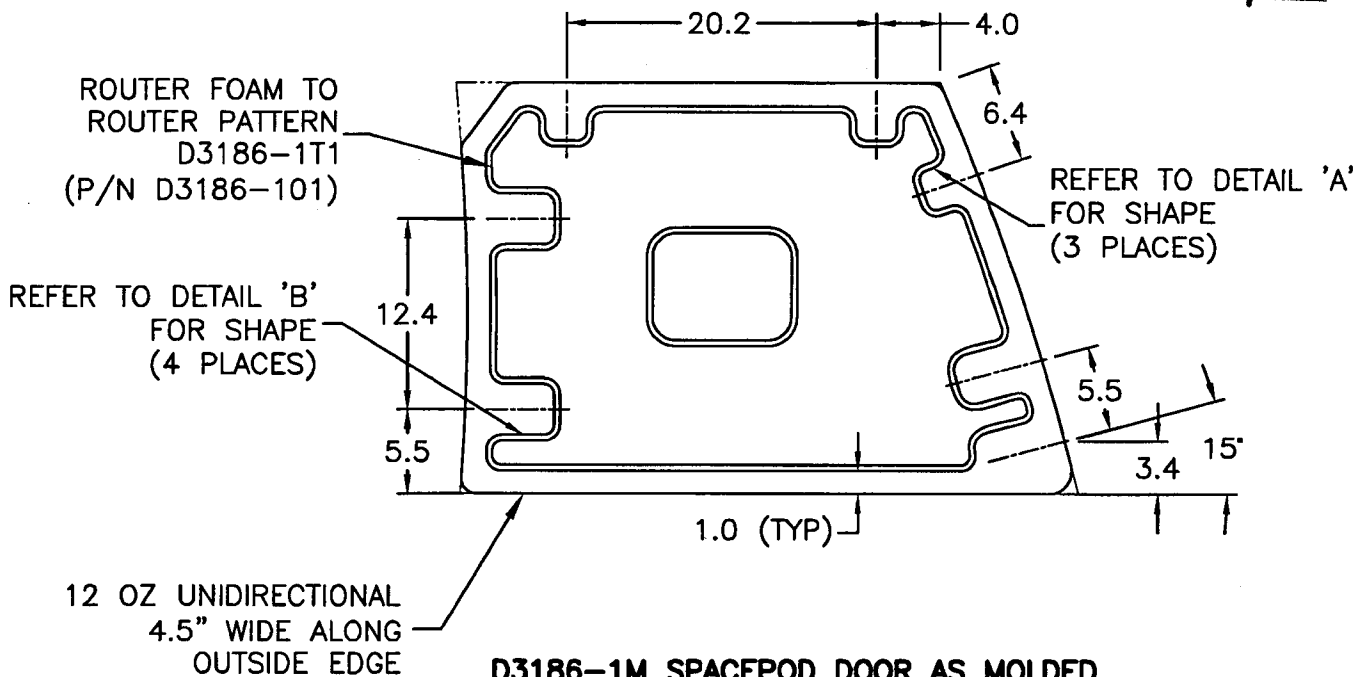
**NOTE:** Date & initial all entries

**DART**

|                     |                        |   |                        |
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| CHECKED<br><i>B</i> | APPROVED<br><i>H</i>   | DRAWING NO.<br>D3186  | REV. D<br>SHEET 1 OF 5 |
| DATE<br>07.02.22    | TITLE<br>SPACEPOD DOOR |   | SCALE<br>NTS           |
| A                   | 03.03.27               | NEW ISSUE   |                        |
| B                   | 06.09.25               | DIMS UPDATED TO MATCH PRODUCT<br>FOAM PATTERN UPDATED<br>D3186-1M/-2M/-3/-4 ADDED |                        |
| C                   | 06.12.13               | REMOVED D0600-XXX LABELS  |                        |
| D                   | 07.02.22               | UPDATE DIMENSIONS   |                        |

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**07.02.27 *H***D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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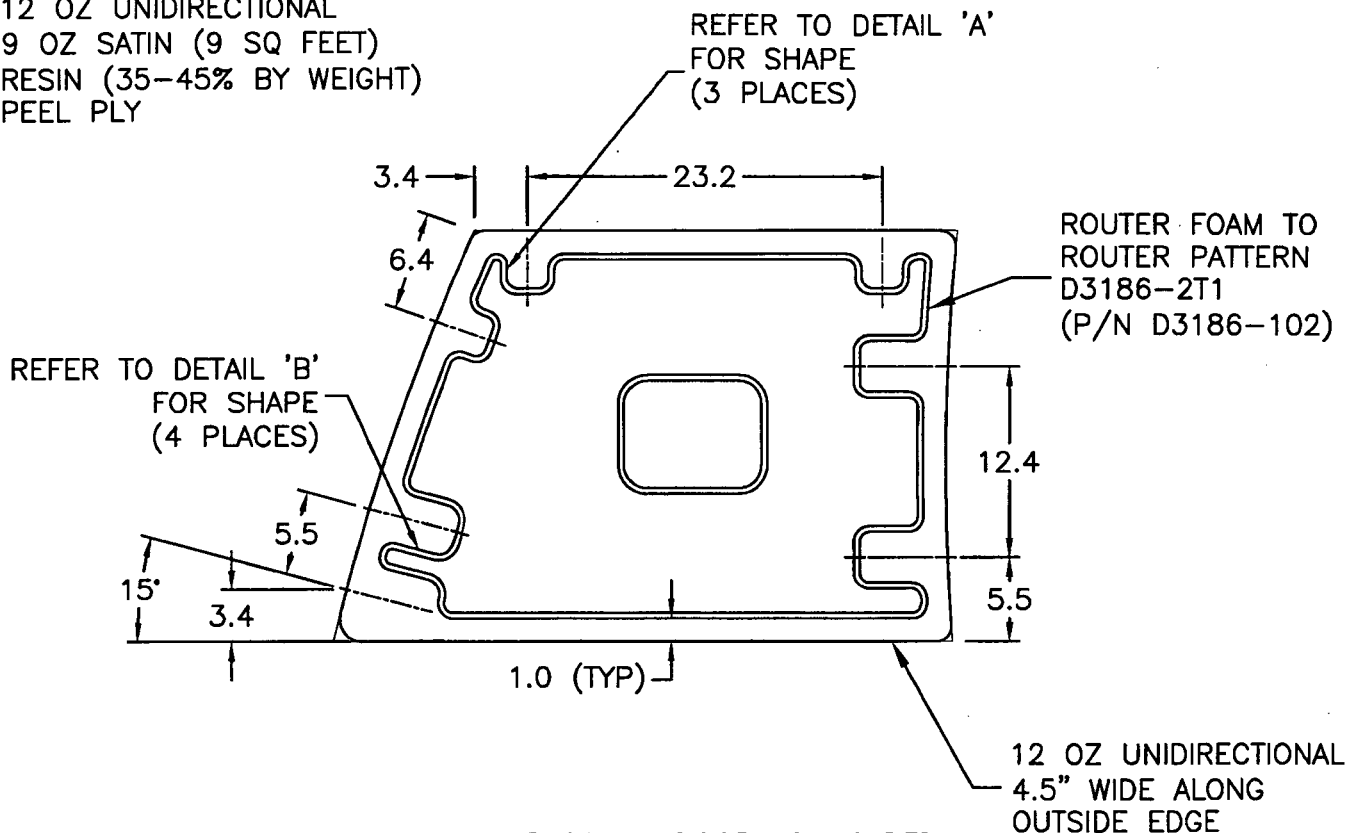
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| DATE<br>07.02.22 | TITLE<br>SPACEPOD DOOR |   | SCALE<br>NTS           |

**MAIN LAYUP**

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY

**RELEASED**

07.02.27

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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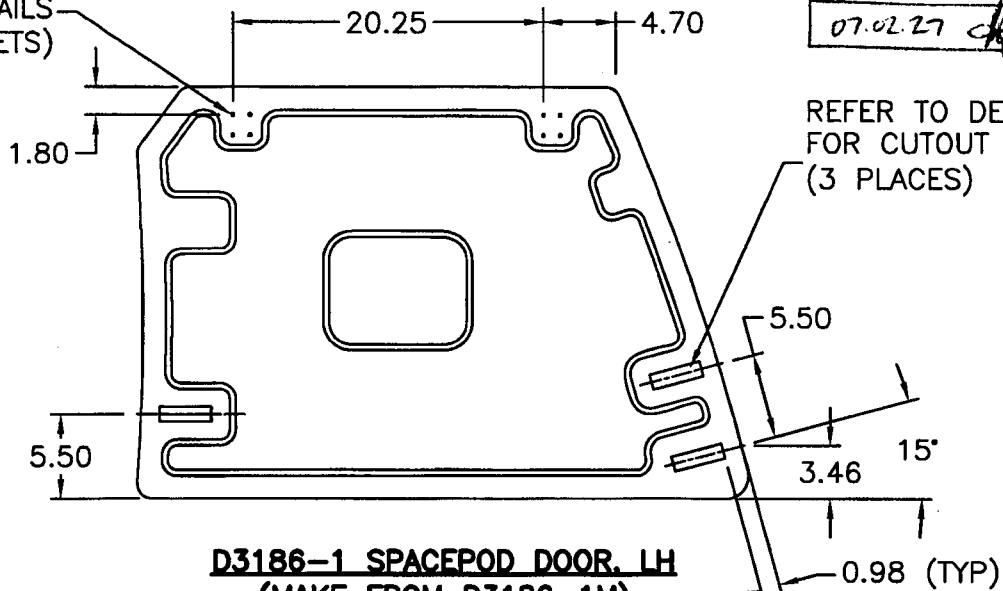
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| DATE<br>07.02.22 | TITLE<br>SPACEPOD DOOR |   | SCALE<br>NTS           |

REFER TO DETAIL 'C'  
FOR HOLE DETAILS  
(2 SETS)

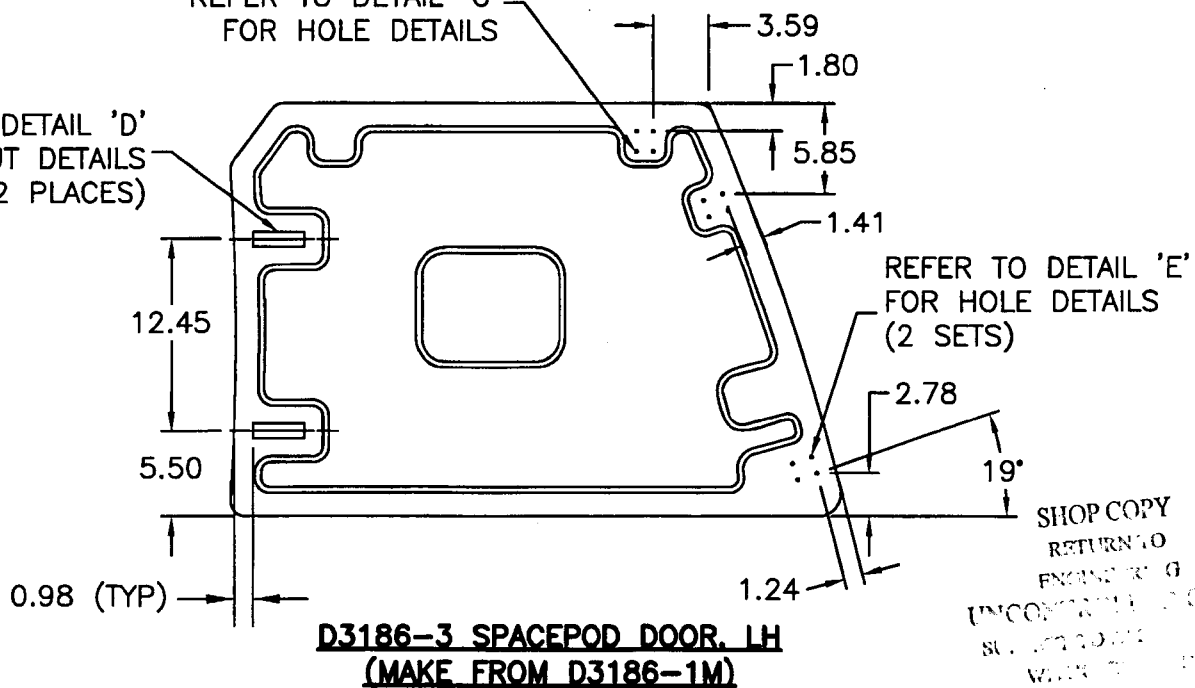
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07.02.27

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(3 PLACES)

REFER TO DETAIL 'C'  
FOR HOLE DETAILS

REFER TO DETAIL 'D'  
FOR CUTOUT DETAILS  
(2 PLACES)



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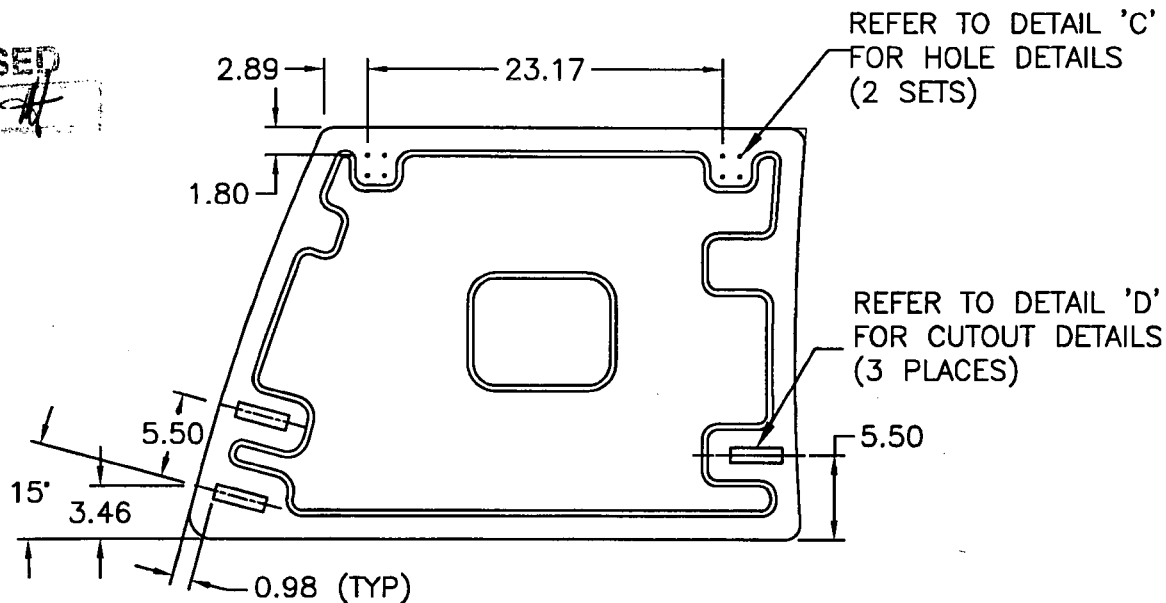
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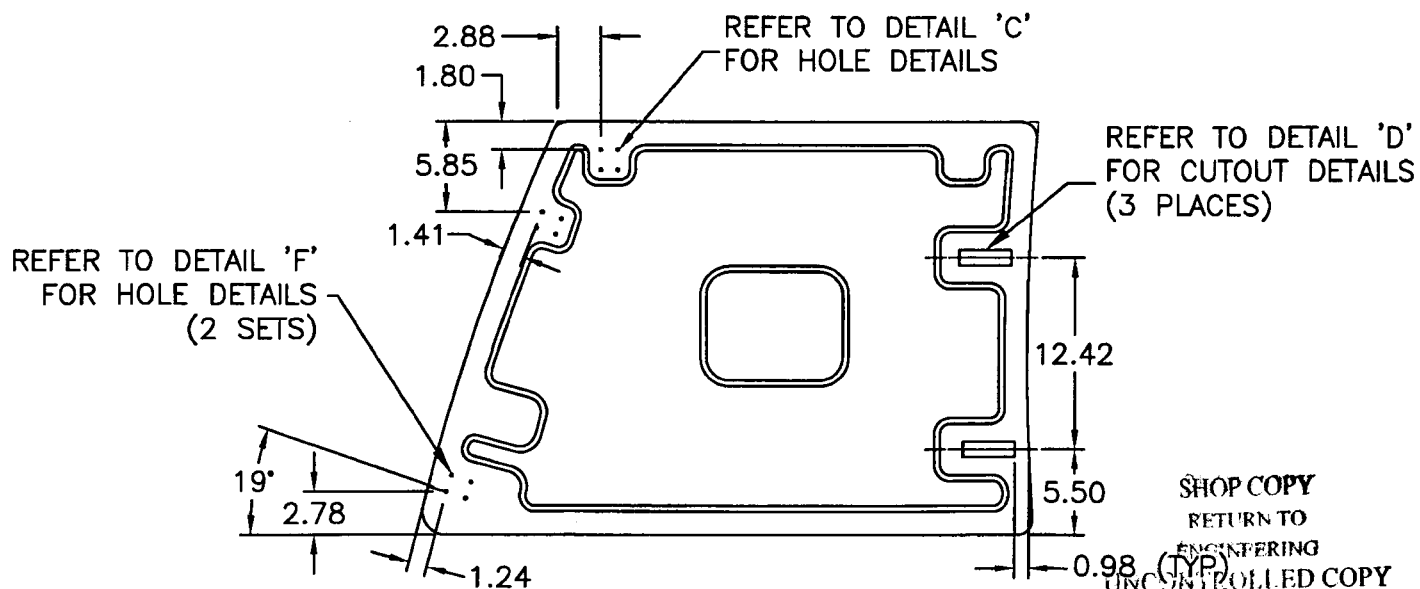
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| DATE<br>07.02.22 | TITLE<br>SPACEPOD DOOR |   | SCALE<br>NTS           |

**RELEASED**

07-02-27



**D3186-2 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**



**D3186-4 SPACEPOD DOOR. RH**  
**(MAKE FROM D3186-2M)**

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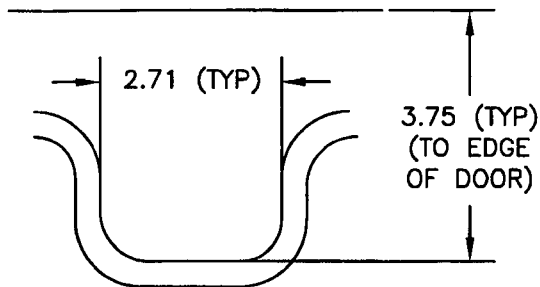
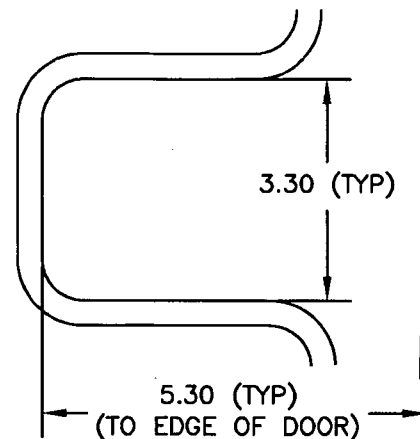
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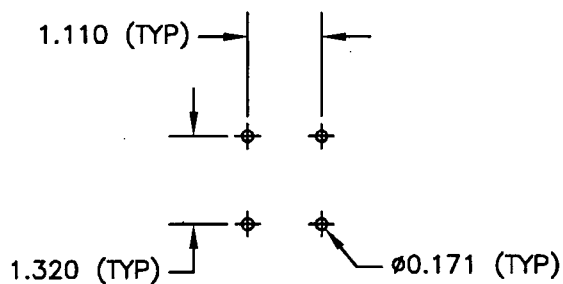
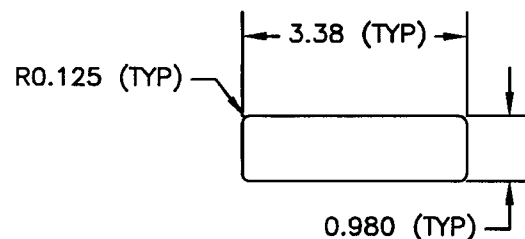
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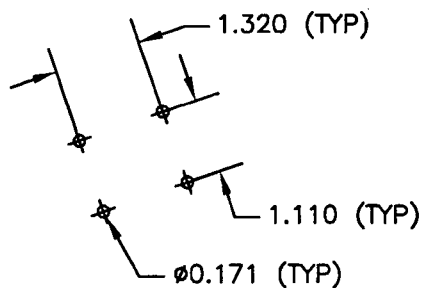
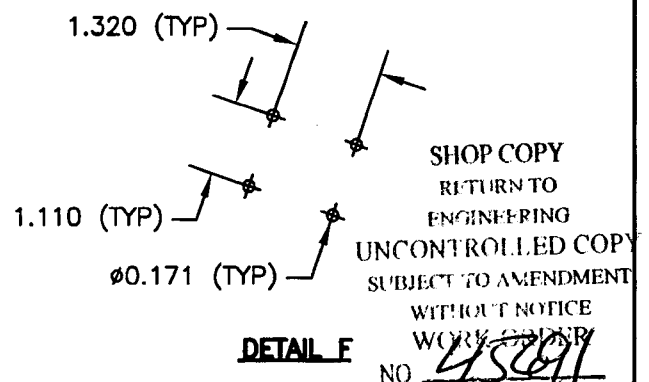
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| DATE<br>07.02.22       | TITLE<br>SPACEPOD DOOR  |   | SCALE<br>NTS           |

**DETAIL A****DETAIL B****RELEASED**

07.02.27 [Signature]

**DETAIL C**

NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D****DETAIL E****DETAIL F****NOTES:**

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